

Work Order ID 136549

September 02, 2015 3:44:18 PM

136549

Page 1

Item ID: D4324-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm Support Assembly
 Start Date: 9/1/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/1/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SH Date: 0150903 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4324	B

100 Weld per dwg A/R S.S. rod Batch: m123823 0.00

100

Large Fab Memo 0.00
 Large Fab

21 22 16-02-04

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00
 Quality Control

DAS
50
1 15-2-18 9-89

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00
 Quality Control

DAS
9
1 1602-16 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 136549

September 02, 2015 3:44:18 PM

136549

Page 2

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Revision ID: Stop ***NS2***
Item Name: Arm Support Assembly
Start Date: 9/1/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/1/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>Flair</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
									<i>FEB 16 2016</i>
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									
									<i>MCS</i>
									<i>FEB 16 2016</i>

MCS FEB 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																										
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

September 02, 2015 3:44:22 PM

Page 1

Work Order ID: 136549

136549

Parent Item: D4324-043

D4324-043

Parent Item Name: Arm Support Assembly

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.04 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN310C3 *AN310C3* NUT		Purchased	No			100	Each	84.0000	1	1			
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DAS
6
9-89

Location	Loc Qty	Loc Code
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GA	70	
M128429	20	
M131467	50	
ST331	14	
M128818	14	

D4324-3 *D4324-3* Support Plate		Manufactured	No			100	Each	2.0000	1	1			
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**

DAS
6
9-89

Location	Loc Qty	Loc Code
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ST101	2	
123061	2	

D4324-7 *D4324-7* Tube		Manufactured	No			100	Each	1.0000	1	1			
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**

DAS
6
9-89
FEB 03 2016

Location	Loc Qty	Loc Code
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ST101	1	
116635	1	

DQA: _____ Date: _____

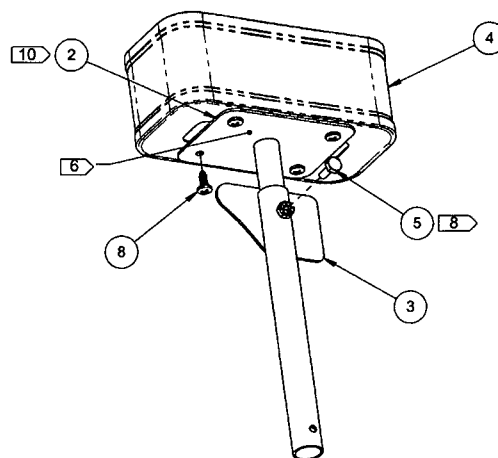


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																



D4324-011 ARM REST ASSEMBLY
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16) 

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.83 lbs
- 8) INSTALL HARDWARE HAND TIGHT ONLY
- 9) BAG LOOSE HARDWARE
- 10) CENTER D4324-041 ON D4324-045 AS SHOWN

ITEM	QTY -011	P/N	DESCRIPTION
1	X	D4324-011	ARM REST ASSEMBLY
2	1	D4324-041	ARM REST WELDMENT
3	1	D4324-043	ARM SUPPORT ASSEMBLY
4	1	D4324-045	CUSHION ASSEMBLY
5	3	AN3-4A	BOLT
6	1	AN3-12A	BOLT
7	3	MS21075L3	NUT PLATE
8	4	MS51861-45C	SCREW
9	3	NAS1149F0332P	WASHER
9	10	NAS1149F0363P	WASHER

RELEASED
2014-04-23
MD

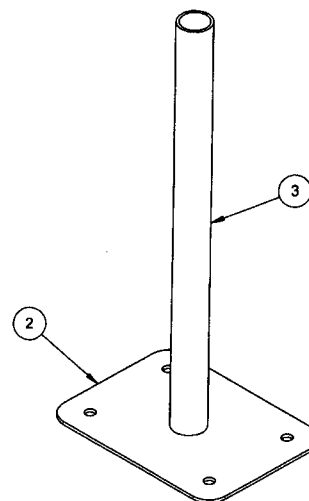
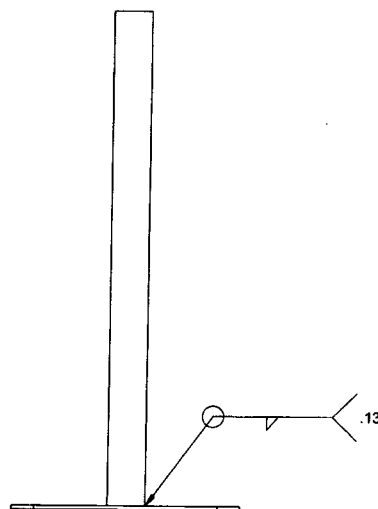
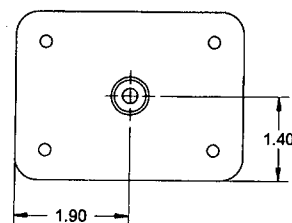
120150903 SH 136589

B	ADD D4324-011 (ZN B4-1) & D4324-045 (ZN B4-4); REVISE D4324-041 NAME (ZN B4-2, D4-2); ADD Ø0.204 HOLES (ZN D5-5) & Ø0.25 HOLE (ZN D4-5); 8.30 WAS 8.95 (ZN C5-7); REVISE IDENTIFICATION NOTES; REF PAR13-319	RF	14.04.03
A	NEW ISSUE	RF	11.01.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 1 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
DATE	14.04.03	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DAMAGED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4324-041	ARM REST WELDMENT
2	1	D4324-1	BASE PLATE
3	1	D4324-5	TUBE



D4324-041 ARM REST WELDMENT
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) B

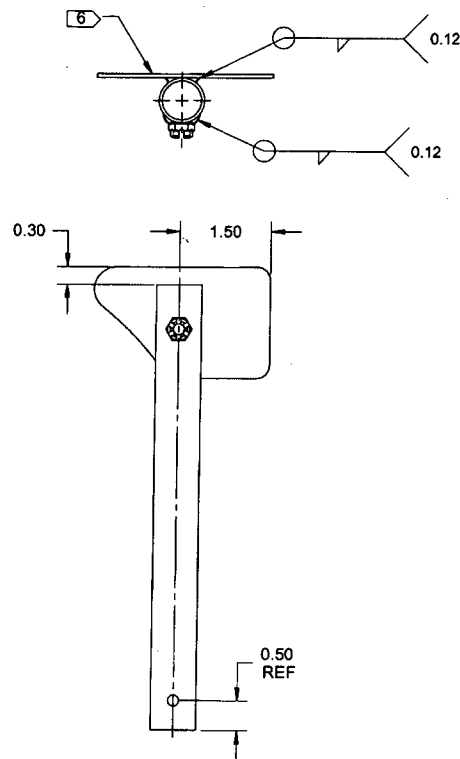
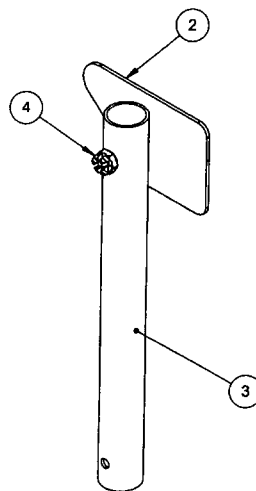
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.40 lbs
 - 8) WELD PER DART QSI 004

RELEASED
2014-04-23

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	DC	DRAWING NO.	REV. B
	MFG. APPR.	DD	D4324	SHEET 2 OF 7
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	ARM REST ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4324-043	ARM SUPPORT ASSEMBLY
2	1	D4324-3	SUPPORT PLATE
3	1	D4324-7	TUBE
4	1	AN310C3	NUT, CASTELLATED



D4324-043 ARM SUPPORT ASSEMBLY
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.32 lbs
- 8) WELD PER DART QSI 004

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 3 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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2014-04-23

8 7 6 5 4 3 2 1

D

C

B

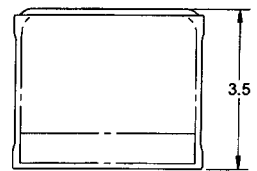
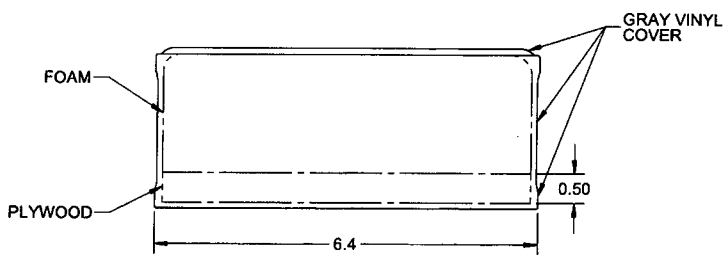
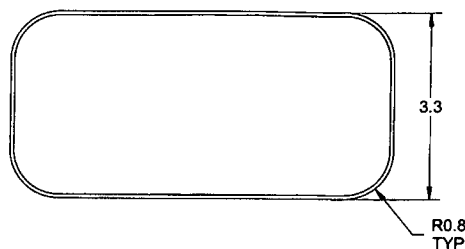
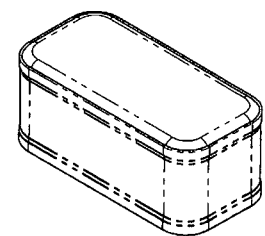
A

D

C

B

A



D4324-045 CUSHION ASSEMBLY
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)

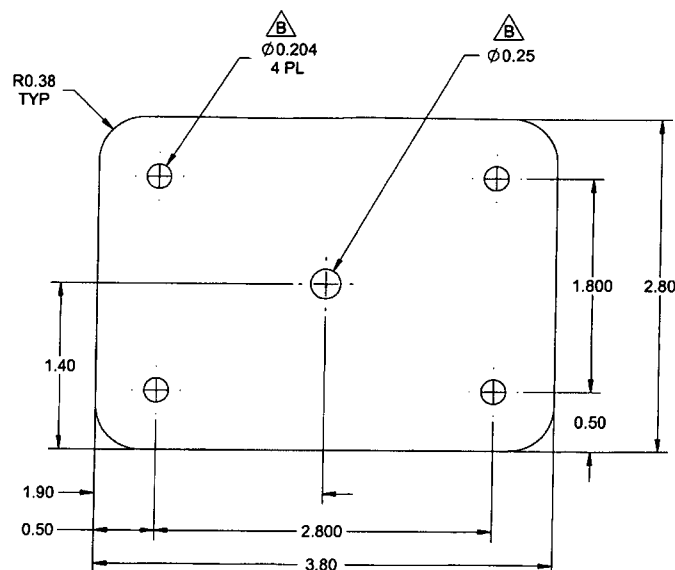
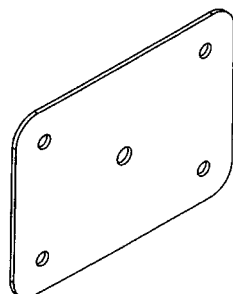
RELEASED
2014-04-23
WD

- NOTES:
1) MATERIAL: AS SHOWN
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 4 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D4324-1 BASE PLATE
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) $\triangle B$

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 5 OF 7
APPROVED	HS	TITLE	SCALE
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2014-04-23

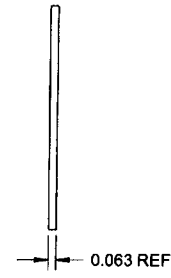
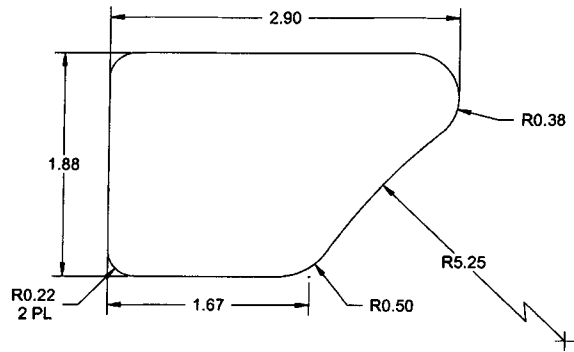
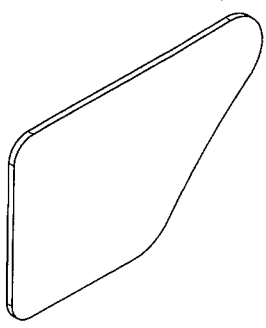
8 7 6 5 4 3 2 1

D

C

B

A



D4324-3 SUPPORT PLATE
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)

- NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
 ANNEALED
 2B FINISH
 PER MIL-S-5059
 OR AMS 5513 (304)
 OR AMS 5524 (316)
 OR ASTM A240
 OR ASME SA240
 REF DART SPEC. M304S16GA
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.08 lbs

RELEASED
2014-04-23
WDP

RELEASED
2014-04-23

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 6 OF 7
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8 7 6 5 4 3 2 1

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7

6

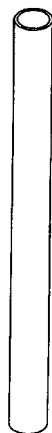
5

4

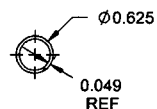
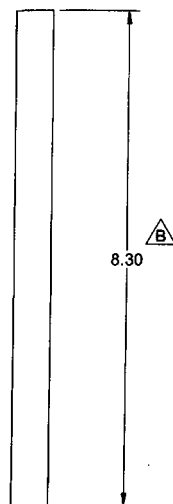
3

2

1

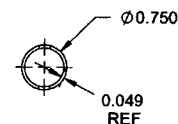
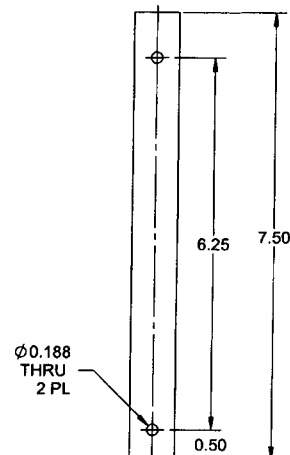


D4324-5 TUBE



D4324-5 TUBE

(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)



D4324-7 TUBE

(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)



D4324-7 TUBE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC. M304TR0.625W.049 & M304TR0.75W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4324-5 = 0.21 lbs
D4324-7 = 0.23 lbs

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 7 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
DATE	14.04.03	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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2014-04-23